Work Order ID 77110 *77110*
November-25-11 1:38:04 PM

Item ID:	D2055	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Clamp	**Stop**	*NS2*
Start Date:	25/11/2011	**Start Qty:** 20.00	*20*
Required Date:	09/12/2011	**Req'd Qty:** 20.00	*20*
Cust Item ID:		**Customer:**	
Reference:			

Approvals: **Process Plan:** M.L.J **Date:** 11\11\25 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1* **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2055	**Revision Nbr** Rev C1									
100 *100* Doosan Doosan Lathe	Hardinge CNC LATHE SMALL **Memo** Machine as per Folio FA203 deburr all sharp edges as per dwg	0.00 0.00	SL 12/3/14				21	Ø		
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00	SL 12/3/14				21	Ø		
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00	SL 12/03/14							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 77110

November-25-11 1:38:04 PM

77110

Item ID: D2055

Revision ID:

Item Name: Clamp

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 25/11/2011 **Start Qty:** 20.00 *20*

Required Date: 09/12/2011 **Req'd Qty:** 20.00 *20*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ____________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ____________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				21	Ø		12/03/14
	Memo	0.00							
160 *160* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00				21	Ø		12/03/16.
	Memo START TIME: 9h30 OVEN TEMPERATURE: 320°F FINISH TIME: 16h00	0.00	M115128						
170 *170* QC Quality Control	QC3- Inspect Part Finish	0.00				21	Ø		12/03/16
	Memo	0.00							

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ________ **Disposition:** ________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77110

November-25-11 1:38:04 PM

77110

Item ID: D2055

Revision ID:

Item Name: Clamp

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 25/11/2011 **Start Qty:** 20.00 *20*

Required Date: 09/12/2011 **Req'd Qty:** 20.00 *20*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: ST GA	0.00			21X	SP	12-03-16		
	Memo	0.00							
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					12/3/19		
	Memo	0.00							

12-03-14

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-25-11 1:38:09 PM

Work Order ID: 77110 *77110*

Parent Item: D2055 *D2055*

Parent Item Name: Clamp

Start Date: 25/11/2011 **Required Date:** 09/12/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP C02.03.07Now turned in houseNG IPP REV:D NOW ON DOOSAN 10-02-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 *M6061T6R1.000* ROUND BAR 1.00"		Purchased	No			120	f	44.7830	0.1042 **	2.193684		12/3/14	

Location	Loc Qty	Loc Code
MAT013	44.783	
116406	14.303	
118271	30.48	

2.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ________________ **Disposition:** ________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	77110
Description: Clamp	Part Number:	D2055
Inspection Dwg: D2055 Rev: C1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓		[illegible]	[illegible]
1.000	+/-0.010	1.000	✓			
0.063	+/-0.010	.061	✓			
0.090	+/-0.010	.090	✓			
0.513 – 0.518	N/A	.514	✓			
0.623 – 0.625	N/A	.624	✓			
0.750	+/-0.010	.751	✓			
Ø0.191	+0.005/-0.001	.192	✓			
0.300	+/-0.010	.300	✓			

Measured by:	[signature]
Date:	12/3/14

Audited by:	[signature]
Date:	12/03/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.02.02	New Issue	KJ [signature]	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

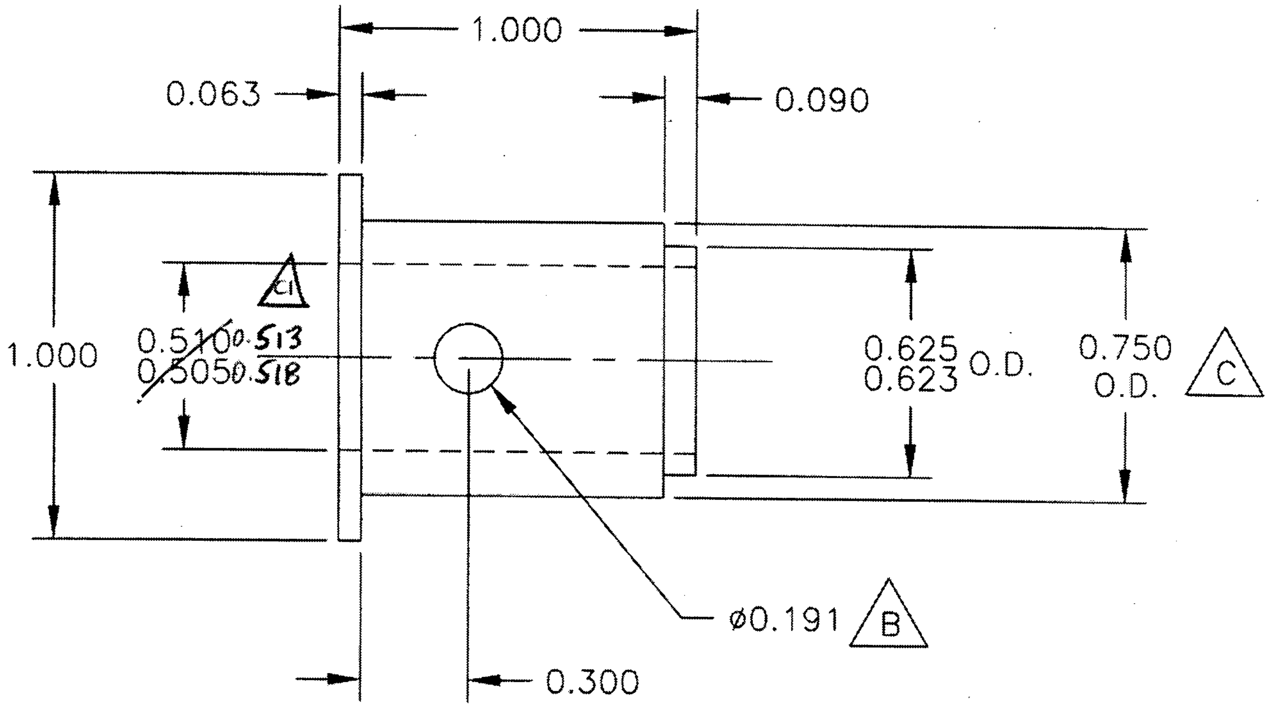
DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	CP	
CHECKED	APPROVED	DRAWING NO. D2055 — REV. C — SHEET 1 OF 1
KE	[illegible]	
DATE		TITLE — SCALE
98.12.10		CLAMP — 2:1

REV	BY	DATE	DESCRIPTION
A		92.03.13	NEW ISSUE
B		98.10.15	0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH
C		98.12.10	ADDED 0.750 O.D. DIMENSION
C1	CP	01.06.05	MODIFY HOLE SIZE, ADD P/C OPTION

RELEASED 98.12.10 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77110 M.L.J
11/11/25

C1
ACID ETCH + ALODINE PER
DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3

MATERIAL: 6061–T6 ROD (QQ–A–225/8)
FINISH: BLACK ANODIZE OR
BREAK ALL SHARP EDGES 0.015 MAX
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE